



NOTES:

- THIS IS A ULTRA - HIGH - VACUUM ASSEMBLY (UHV). KEEP THE UHV PARTS CLEAN DURING ASSEMBLY, AND AND WRAP UP FOR PACKING WITH ALUMINUM FOIL.
- WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
- THIS IS A UHV PART. ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
- THE ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:
ALCATEL ASM-110TCL
VARIAN NCR 925 OR 936
VEECO MS-9, MS-90 OR MS-18
Du PONT CEC 24-120B
CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.
FINAL TEST WILL CONSIST OF SURROUNDING THE CHAMBER (BAGGING) WITH HELIUM. THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.
- DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

REF. SOURCE
MCD VACUUM PRODUCTS CORP.
23842 CABOT BLVD.
HAYWARD, CA. 94545-1651
1-800-443-6817
FAX: 510-887-0626

2		#100026	6.00 O.D. ROTATABLE CON. VACUUM FLANGE		SST	2
1			4.00 O.D. X .12 WALL X 5.38" LG.		SST	1
ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION			MATERIAL / SPEC	QTY
PARTS LIST						
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONS DECIMALS ANGLES X .XX - .001 (0.025) .XX - .005 (0.127)		LOG NUMBER A2186900	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY			
DRAWN BY FUHRMANN		DATE 12/14/95	CHIEF DESIGN ENGINEER D. SHU	DATE 3/5/95	TITLE ADVANCED PHOTON SOURCE	
CHECKED BY W. YUN		DATE 2/23/95	SP. LIAISON T.M. KUZAY	DATE 3/6/95	Y2 LONG COOLED HORIZONTALLY DEFLECTING X-RAY MIRROR	
DESIGNER D.SHU/FUHRMANN		PROJECT MGR. D. SHU		6" FLANGE ADAPTER WELDMENT		
RESPONSIBLE ENGINEER D. SHU		APPROVED/RELEASED				
MATERIAL SEE PARTS LIST		SCALE 1:1		SHEET 1 of 1		
BYM		CHANGE DESCRIPTION		BY		CHKD DATE
REVISIONS						
DRAWN BY DATE						